



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5374-3**Job Sheet 207190****Part No:** D5374-3**Job Qty:** 100 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/19/20**Job Tracking No:****Due Date:** 3/30/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP REV:A NEW ISSUE 15-12-10 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	DAS Sign-off
					Setup Hrs	Run Hrs		
100	Hardinge - 1	100 pcs	3/30/20	3/30/20	0.50	9.71	Hardinge - 1	66 20/03/08
120	QC 8	100 pcs	3/30/20	3/30/20	0.00	0.00	QC 8 - 12	9-89
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	J.C. L. 2008-08
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	
							QC 8 - 61	
130	Packaging 3-1 - Stock - B4B	100 pcs	3/30/20	3/30/20	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	

Part: D5374-3
Job No: 207190
Serial No/Batch: S261631
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 03/08/20



Plex 2/19/20 2:42 PM Dart.lajeunesse.marie

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	DAS
				Packaging 3 - 23 - B4B	84
				Packaging 3 - 24 - B4B	9-89
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	100 pcs	3/30/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - 1-TURN AS PER FOLIO FB445 & DWG D5374
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

MAR 09 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.500	303 Round Bar 0.500"	18.2000 ft (.182 ea)	100-Hardinge - 1	S243/05

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303R0.500	18	70	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.500Inches + 0.006 - 0.001	0.506 0.499	.498	Diameter
2	Bushing	0.313Inches + 0.000 - 0.003	0.313 0.310	.312	Diameter
3	Bushing	30.000Degrees ± 0.500	30.500 29.500	30.	Angle
4	Bushing	0.035Inches + 0.030 - 0.010	0.065 0.025	.033	
5	Bushing	2.050Inches + 0.000 - 0.005	2.050 2.045	2.047	
6	Bushing	0.020Inches ± 0.030	0.050 (0.010)	.020	Radius
7	Bushing	0.050Inches + 0.000 - 0.005	0.050 0.045	.048	
8	Bushing	0.196Inches ± 0.005	0.201 0.191	.197	Diameter
9	Bushing	0.226Inches + 0.010 - 1.000	0.236 (0.774)	.220	
10	Bushing	90.000Degrees ± 0.500	90.500 89.500	90.	Angle

Plex 2/19/20 2:42 PM Dart.lajeunesse.marie

Date:



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation		Disposition							
		Completed By							
		Lead hand / Supervisor							
		QC / QA Coordinator							

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>Pressure/Forced ☐</td> <td>Contamination ☐</td> <td>Power Loss/Surge ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Bending ☐</td> <td>Misaligned/off center ☐</td> <td>Folio/Program ☐</td> <td>Outside Tolerance ☐</td> </tr> <tr> <td>Crushing ☐</td> <td>BOM/Route ☐</td> <td>Grain Direction ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist ☐</td> <td>Incomplete/Unclear Instructions ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Out of Sequence ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Mislabeled ☐</td> <td>Fit/Function ☐</td> <td>Off-set/Set-up ☐</td> <td></td> </tr> </table>										Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐	
Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																				
Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐																																				
Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐																																				
Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																				
Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐																																				
Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐																																					
		Other/Details:																																					